

Work Order ID 164535

Thursday, July 20, 2017 11:31:15 AM

164535

Ship Aug 2

Page 1

Item ID: D3562-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Weldment
 Start Date: 7/20/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/28/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

JUL 20 2017

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	G								

100 0.00
 100 Large Fab
 Large Fab Memo 0.87
 Large Fab 1-Cut D2622 extrusion as per Dwg D3562
 2-Deburr and bevel ends for welding

1x DC 2017-07-20

110 0.00
 110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

1 38 9-89
 JUL 21 2017

120 0.00
 120 Chemical Conversion Coat per QSI005 4.1
 HandFinish Memo 0.37
 Hand Finishing

(x1) 2017/07/24
 BEB.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment
Start Date: 7/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							DAS
130									24
QC	Memo	0.01							9-85

Quality Control

140		0.00							
140	Small Fab								
Small Fab	Memo	0.74							
Small Fab	1- Transfer drill Rivet holes as per dwg D3562.								
	2-Touch-up rivet holes with alodine as per dwg d3562								
	3-Rivet legs using Scotch-Weld as per dwg D3562.								
	*****Ensure to wipe off any excess magnobond *****								

A/R Scotch-Weld DP460

Batch: 1360223

EXP DATE: 11/17

1x DC 2017-07-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval ☐	
Description Work Order Deviation		Disposition			
				Completed By _____	
				Lead hand / Supervisor Approval Verification ☐	
				QC / QA Coordinator Approval ☐	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Start Date: 7/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1			DAS 38 9-89 JUL 27 2017
160 *160* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: _____ Large Fab Memo 1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>M136158</u> 2-Grind end cap welds flush as per Dwg D3562	0.00 1.05							x/ S.L 2017.07.27
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							① 17.07.27 DAS 9 9-89

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

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Required Date: 7/28/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				①	17-07-27		DAS 9 9-89
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.17				(X)		2017/07/27 BEB.	
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M138014 Memo START TIME: 3:30 OVEN TEMPERATURE: 320° FINISH TIME: 4:00	0.00 0.31				1	φ 17-07-27		2338

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☒ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : <u>17-07-28</u>		Step #: <u>200</u>		QTY Effective : <u>1</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
<i>pro seal leaks on arm of the step after heating</i>				<i>- Tape the all step</i> <i>- scuff the arm</i> <i>- repowder coat</i> <i>in 13801H START: 10:05</i> <i>OV.T: 820°</i> <i>FINISH: 10:35</i>				Completed By <u>17-07-28</u> Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☒	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	☒ Finish				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 7/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/28/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210 *210* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>1113794.00</u> Memo	0.38				1	1	14/07/13	
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220 *220* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				1			DAS 38 9-89 AUG 01 2017
--	--------------------------------------	--------------	--	--	--	---	--	--	----------------------------------

230 *230* Packaging Packaging	Identify as per dwg & Stock Location: <u>sold</u> Memo	0.00 0.01							DAS 28 9-89 AUG 01 2017
---	---	--------------	--	--	--	--	--	--	----------------------------------

Work Order ID 164535

Thursday, July 20, 2017 11:31:15 AM

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment
Start Date: 7/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
240									
QC	Memo	0.10							
Quality Control									

**DAS
21
9-89**

AUG 01 2017

Picklist Print

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Page 1

Work Order ID: 164535

164535

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 7/20/2017

Required Date: 7/28/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
 13.06.03 PER DWG REV.F DD VERF:JLM IPP REV:F 16.06.23
 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2622-120C Step Extrusion		Manufactured	No			100	Each	9.5000	1	1			
** DC 2017-07-20													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA003	9.5	B157441 →	1				
						152316	2						
						157441	7.5						
✓ D2734 Step End Plate		Manufactured	No			140	Each	47.0000	2	2			
** DC 2017-07-20													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA003	47	B16519 →	2				
						161519	47						
D3560-042		Manufactured	No			140	Each	0.0000	1	1			
✓ *D3560-042*													
B164536 → 1x ** DC 2017-07-20													
Arm Weldment													
D3560-044		Manufactured	No			140	Each	1.0000	1	1			
✓ *D3560-044*													
** DC 2017-07-20													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA003	1	B160805 →	1				
						160805	1						

Picklist Print

Thursday, July 20, 2017 11:31:18 AM

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Work Order ID: 164535

164535

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 7/20/2017

Required Date: 7/28/2017

Start Qty: 1.00

Required Qty: 1.00

✓ MS20600-AD4W4

Purchased

N.

140

Each

973.0000

32

32

MS20600-AD4W4

**

DC 2017-07-26

Rivet

Location

Loc Qty

Loc Code

CCK004

511

11

M135704

M137820

500

ST308

87

M137587

87

WA003

375

M135442

204

M136986

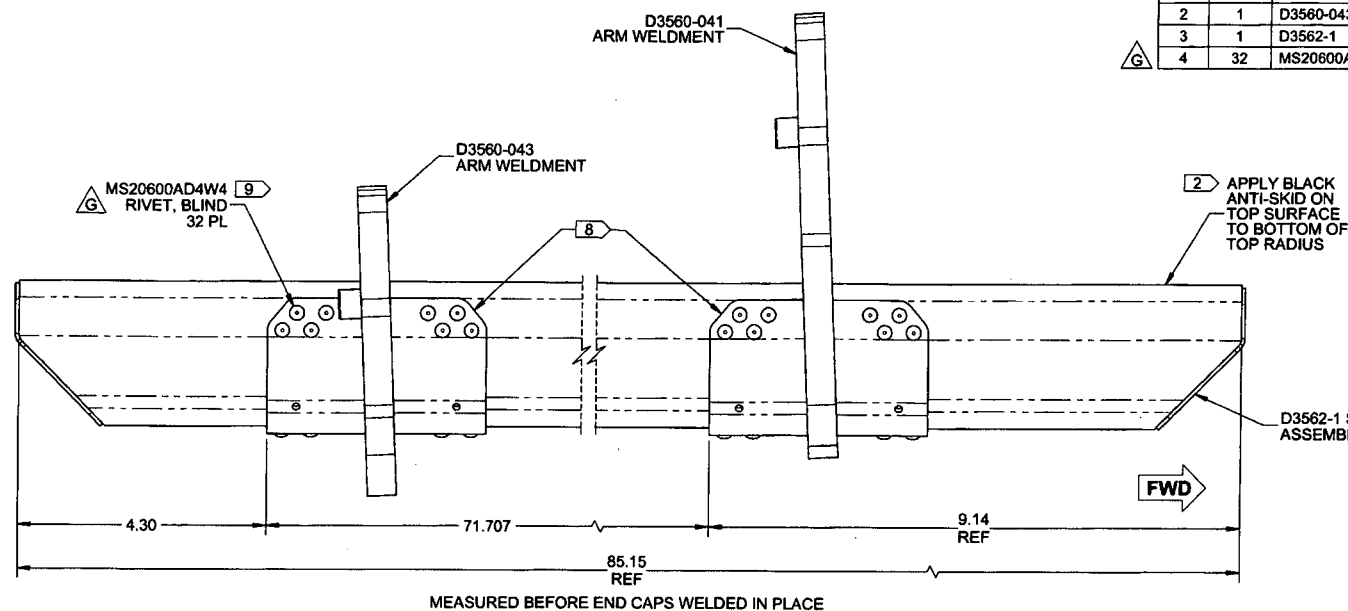
108

M137412

63

B137820 → 35

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3562-041	LH STEP ASSEMBLY
1	1	D3560-041	ARM WELDMENT
2	1	D3560-043	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

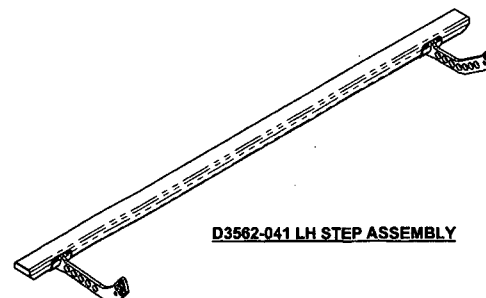
D3562-1 STEP ASSEMBLY TO 164535 MJS
170720

RELEASED

2016 JUN 22 q
ECN 16-661

NOTES:

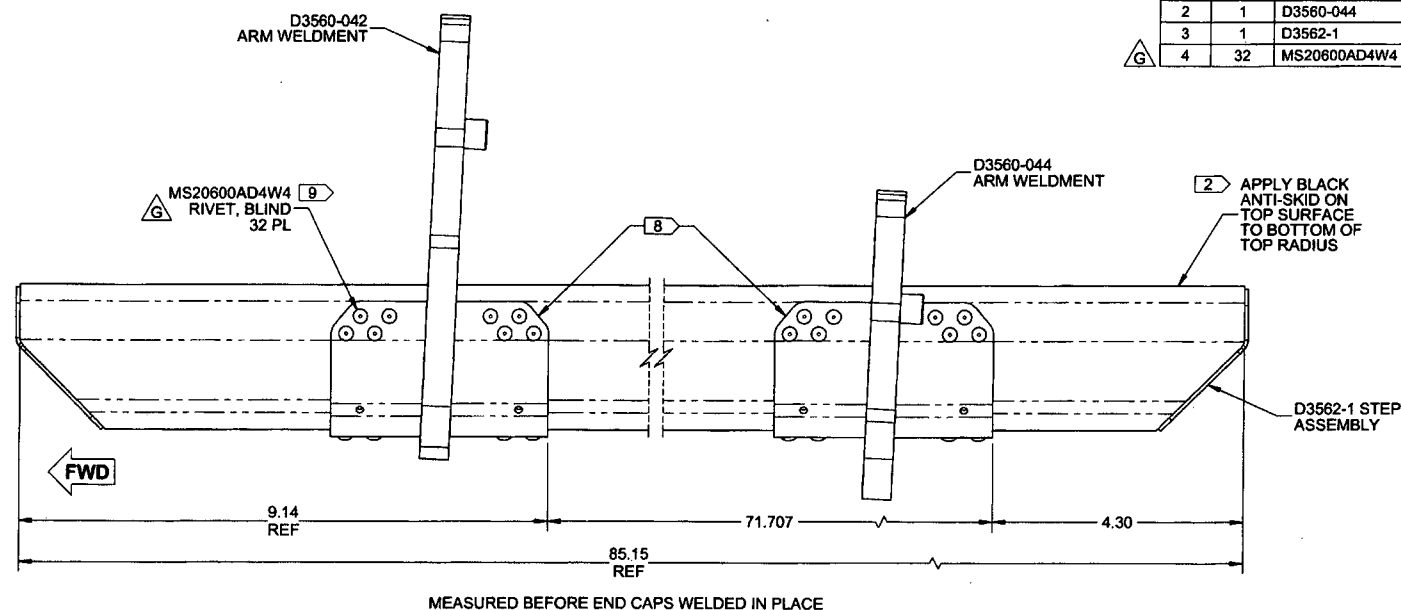
- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY: GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6) OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-041 LH STEP ASSEMBLY

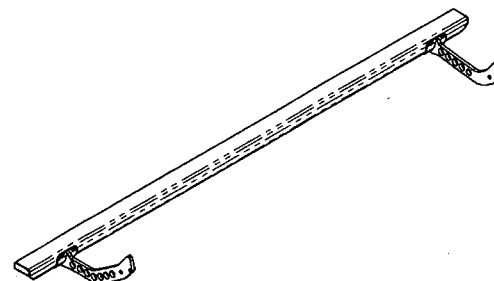
DESIGN	CP	MB	16.04.21
DRAWN	MB	DW	13.05.15
CHECKED	ML	PH	08.01.11
MFG. APPR.	DD	DC	07.11.16
APPROVED	WM	CP	07.06.19
DE APPR.	DS	CP	07.01.15
DATE	16.04.21	CP	06.09.26
DESCRIPTION		BY	DATE
MS20600AD4W4 WAS MS20600AD4WS. REF. PAR16-517.		MB	16.04.21
REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2		DW	13.05.15
ADD QTY(2) TO D2734 END PLATE ON D3562-042		PH	08.01.11
REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS		DC	07.11.16
NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS		CP	07.06.19
ARMS NOW RIVETED TO STEP		CP	07.01.15
NEW ISSUE		CP	06.09.26
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. G	SHEET 1 OF 3
DRAWING NO. D3562		TITLE	SCALE
STEP ASSEMBLY		NTS	
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ITEM	QTY	P/N	DESCRIPTION
	X	D3562-042	RH STEP WELDMENT
1	1	D3560-042	ARM WELDMENT
2	1	D3560-044	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY: GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6) OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-042 RH STEP ASSEMBLY

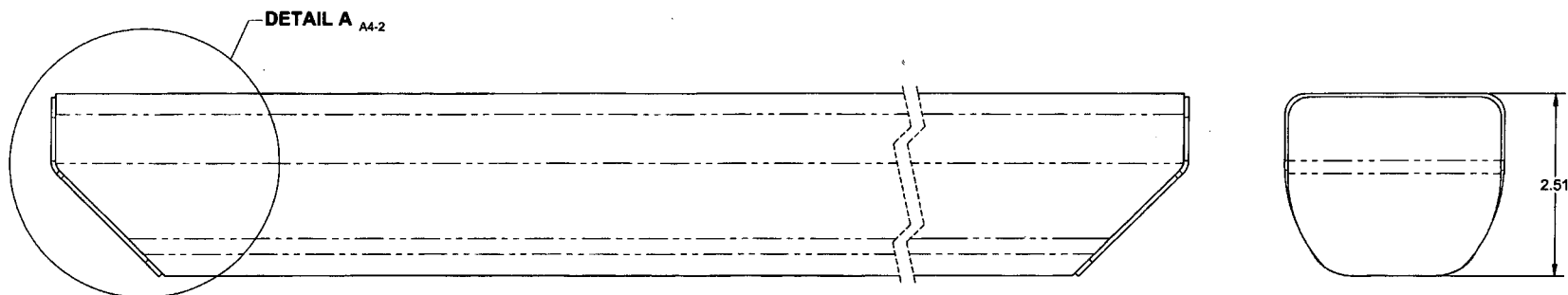
RELEASED

2016 JUN 22 *q*

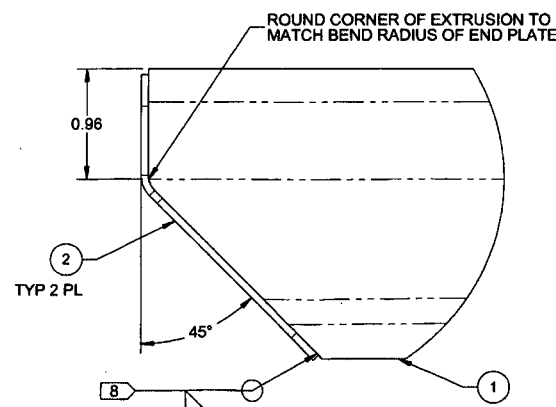
APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. G
MFG. APPR.	DD	D3562	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE



D3562-1 STEP ASSEMBLY



NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.68 lbs
- 8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED
BY A QUALIFIED INSPECTOR PER DART QSI 004

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